

Work Order ID 60194

Monday, June 28, 2010 3:19:23 PM



Page 1

Item ID: D3066-1

Accept



Setup

Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 6/28/2010 Start Qty: 80.00



Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 80.00

Customer:

Reference:

Run

Start



Approvals:

Process Plan:

PP

Date:

10-6-09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3066

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3066

☐ Dwg Rev: *B*

☐ Prog Rev: *B*

☐ 2-

Deburr if necessary

6061 .080

Deburr = 7 m-l 10/07/05

B10-6-30

(106x)

(106)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B10-6-30

Counters

(x106)

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/06/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 7/5/2010 Req'd Qty: 80.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

0.00

JL

10107108

Memo

0.00

106

9

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

106

RR 10-7-8.

150



Packaging

Packaging

Identify as per dwg & Stock Location

PAT

0.00

Memo

0.00

10-7-8

106 SP

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Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 80.00



Customer:

Reference:

Run

Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

100A03
MF
10-8-8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Monday, June 28, 2010 3:19:30 PM

Page 1

Work Order ID: 60194

Parent Item: D3066-1

Parent Item Name: Spacer



Start Date: 6/28/2010

Start Qty: 80.00

Required Date: 7/5/2010

Required Qty: 80.00

Comments: IPP: ☐C☐02.11.01☐Incorporated D3066-1 IPP☐KJ/RF
IPP Rev:B Now M6061-T6 06-06-23 JLM☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.080

Purchased

No

100

sf

89.7699

0.0945

7.957895

10.1



6061-T6 .080 Sheet



1810-6-30

Location

Loc Qty

Loc Code

MAT21

89.76993

113438

2.7512

114351

87.01873

114351

106

Dart Aerospace Ltd

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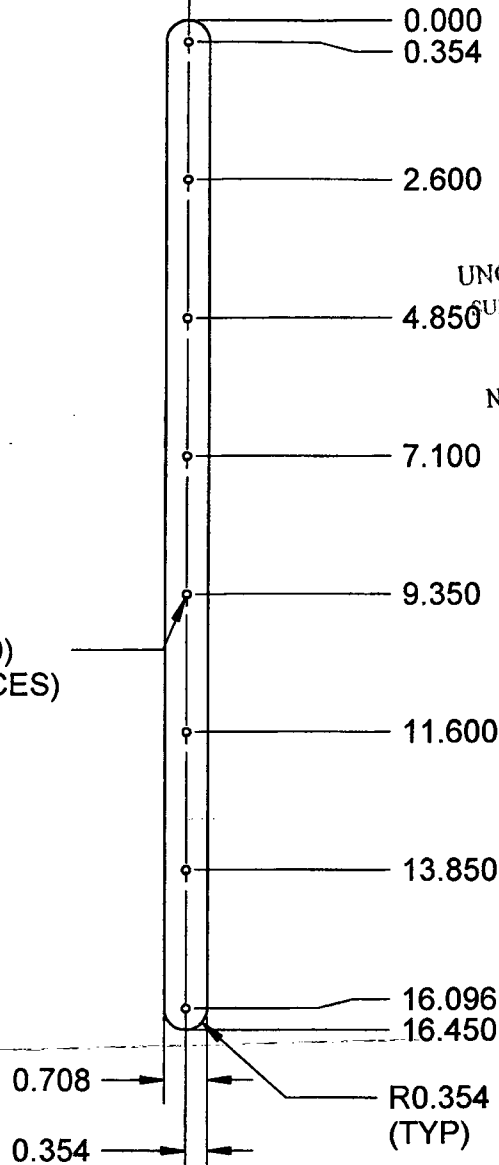
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DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. D3066	REV. B SHEET 1 OF 1
DATE 06.05.29	TITLE SPACER		SCALE 1:3
A	02.09.11	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

RELEASED*06.06.20* *th* $\varnothing 0.128$ (#30)
(TYP 8 PLACES)**D3066-1 SPACER**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.060" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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